

Work Order ID 84881

84881

Page 1

May-29-12 1:01:22 PM

Item ID: D3566-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket

Start Date: 29/05/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3566	Rev C								
100		0.00				33			
100	FLOW WATER JET					<u>33</u>			FB12-G-3
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg D3566 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							FB12-G-3
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control						<u>33</u>			W/120607

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location EP

0.00

130

Packaging

Memo

0.00

Packaging

32

500 12/06/07

→ PTO

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/11
MK
12-06-08

Dart Aerospace Ltd

W/O: 84881		84881 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/06/08		SCAP 1	---	12/06/08	1		

Part No: D3566-5 PAR #: _____ Fault Category: Small Part / water jet NCR: (Yes) No DQA: [Signature] Date: 12/06/08
 Resolution: SCAP Disposition: SCAP QA: N/C Closed Date: 12/6/12

NCR: 12-14916		WORK ORDER NON-CONFORMANCE (NCR) 2.40						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/08		Qk +1 Fanno write holes + tabs missing. Rc sheet over hung while water jetting LCA / operator error	S 05/04/12	Scrap + Destroy Qk +1 No Replace	S 12/06/08	S 12/06/08	S 05/04/12	S 12/06/08

NOTE: Date & initial all entries

Picklist Print

May-29-12 1:01:26 PM

Page 1

Work Order ID: 84881

84881

Parent Item: D3566-5

D3566-5

Parent Item Name: Gasket

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	454.1929	1.06	35.33333	38		
MNEO60S 063											**		
NEOPRENE SHEET 0.063													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT052	454.192884						
						120948	454.192884						
										120948			

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>84881</i>
Description: Gasket		Part Number:	D3566-5
Inspection Dwg: D3566	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	<i>38.50</i>	<i>7</i>		<i>T BAI</i>	
43.50	+/-0.030	<i>43.50</i>	<i>7</i>		<i>T</i>	
5.50 Pitch	+/-0.030	<i>5.50</i>	<i>7</i>		<i>T</i>	
2.50	+/-0.030	<i>2.50</i>	<i>7</i>		<i>T</i>	
2.43	+/-0.030	<i>2.420</i>	<i>7</i>		<i>V BAI</i>	
3.10	+/-0.030	<i>3.090</i>	<i>7</i>		<i>V</i>	
2.50	+/-0.030	<i>2.50</i>	<i>7</i>		<i>T</i>	
0.30	+/-0.030	<i>0.30</i>	<i>7</i>		<i>V</i>	
0.30	+/-0.030	<i>0.30</i>	<i>7</i>		<i>V</i>	
0.063	+/-0.010	<i>0.063</i>	<i>7</i>		<i>V</i>	
6.75	+/-0.030	<i>6.75</i>	<i>7</i>		<i>T</i>	
10.00	+/-0.030	<i>10.00</i>	<i>7</i>		<i>T</i>	
20.00	+/-0.030	<i>20.00</i>	<i>7</i>		<i>T</i>	
30.00	+/-0.030	<i>30.00</i>	<i>7</i>		<i>T</i>	
Ø0.19	+/-0.030	<i>0.190</i>	<i>7</i>		<i>V</i>	

Measured by: <i>RB</i>	Audited by: <i>nhl</i>	Prototype Approval:	N/A
Date: <i>12-6-05</i>	Date: <i>12-06-07</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.06	Ø0.188 dimension removed	KJ/JLM	
D	08.01.16	Dwg Rev updated	KJ/EC/DD	<i>[Signature]</i>

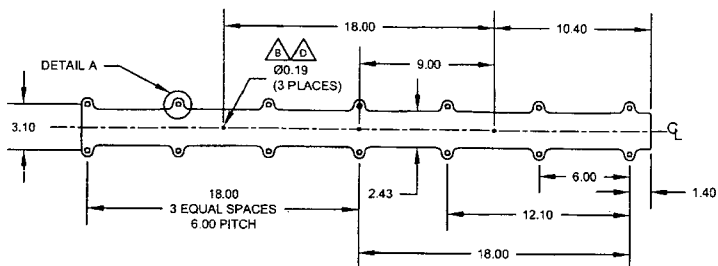
W/O:		WORK ORDER CHANGES					
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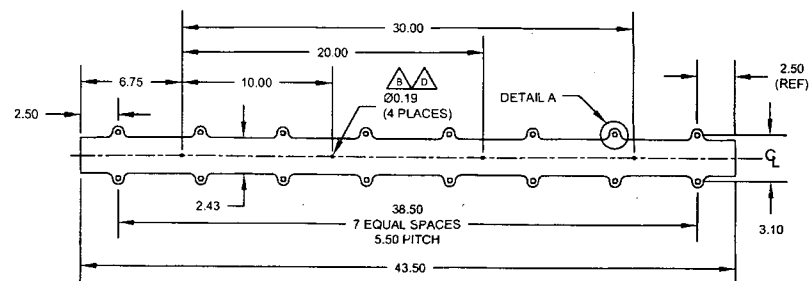
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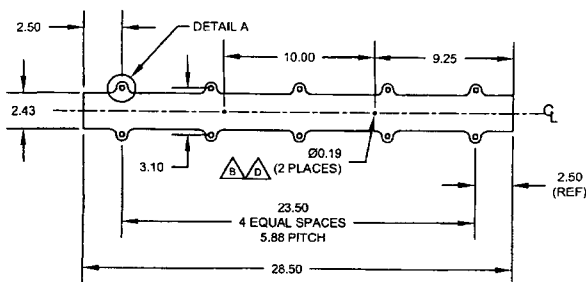
NOTE: Date & initial all entries



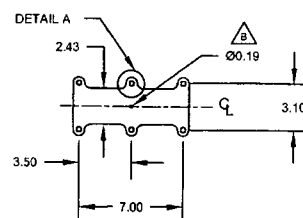
D3566-1 GASKET



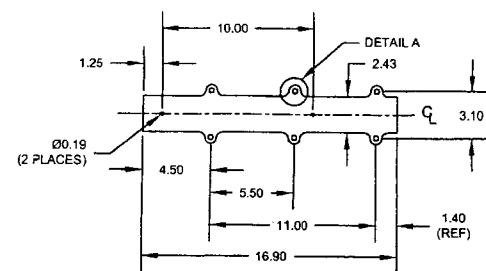
D3566-5 GASKET



D3566-7 GASKET

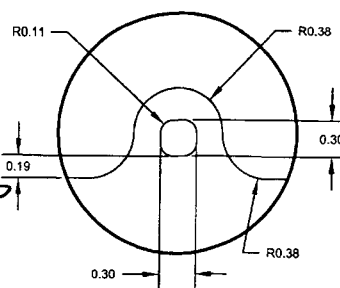


D3566-13 GASKET



D3566-15 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OF YEAR
NO. 84881 MLJ
12/05/30



DETAIL A
SCALE 1:1

WEIGHTS:	
D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

RELEASED

07.08.04

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: SEE TABLE IN ZONE A3
 - 8) PARTS ARE SYMMETRIC ABOUT C

C	UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	DRAWING NO.	REV. C
		D3566	SHEET 1 OF 1
		TITLE	SCALE
		GASKET	1:
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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